Work Orde Monday, March								1	AC	Page
Item ID: Revision ID: Item Name:	D3910-1 Crosstube Lug		Ma	Accept					Setup Star	
	3/29/2010	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item I Customer:	D:			335 P	
Approvals:	Process Plan QC:	: MF	Date: 10-3-39	Tooling: SPC (Y/N):		nte:		I	Run Start Stop	
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revis	sion Nbr				· · · · · · · · · · · · · · · · · · ·				
D3910	В			4-						
Bandsaw Jeaspa Bandsaw		Memo CUT BL	.ANK 1.450" LONG	0.00 0.00	W=10103/29			30	<u>&</u>	
HAAS CNC vertical	machine #1	FOLIO I	NE AS PER FOLIO FA865 AN REV: EV:	0.00 0.00 DIT ND DWG	P10/63/30			20		

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Dart Aerospace Li

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Resolution:			Dispositio	n:	_ QA: N/C C	osed:		Date: _	350170
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	?)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B	Verific		Approval	Approval
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Monday, March 29, 2010 9:54:55 AM

Item ID:	
Revision	ID:

D3910-1





Setup Start

Stop



Item Name:

Start Date:

Crosstube Lug

3/29/2010

Start Qty: 4.00 Req'd Qty: 4.00

Cust Item ID: Customer:

Reference:

Approvals:

Required Date: 4/2/2010

Process Plan:

Date:

Tooling:

Date:

Draw

Rev.

Run-Start

Qty



QC:

Date:

SPC (Y/N):

0.00

0.00

Date:

20

Stop

Sequence ID/ **Work Center ID**

QC

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours** Draw Number Plan Code

Accept Qty

Reject Reject Number Stamp

Insp.

Quality Control

130

QC

Quality Control

QC8- Inspect parts - second check

Memo

Memo

Zo

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

10/03/31

20 \$

Memo

0.00

Dart Aerospace Ltd	D	art	Aero	osp	ace	Ltd
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W/O:			WC	RK ORDER CHANG	ES	a.			
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NCR:		•	WORK ORDI	R NON-CONFORMA	NCE (NCF	1)			
DATE S	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
		Section A	initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
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Monday, March 29, 2010 9:54:55 AM

Item ID:

D3910-1

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Crosstube Lug

3/29/2010

Start Qty: 4.00 Req'd Qty: 4.00

Cust Item ID: Customer:

Reference:

Required Date: 4/2/2010

Approvals:

Process Plan:

Date:

Tooling:

0.00

Date:

Draw

Rev.

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Reject

Sequence ID/ Work Center ID

150

160

QC

Powdercoat

Powder Coating

Operation

Description M 113/70. White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/ **Run Hours**

0.00

Bh 10-4-1

Draw

Number

Code

Plan

Qty Oty

Reject Insp. Number Stamp

QC3- Inspect Part Finish

Memo

0.00

Accept

Quality Control

170

Packaging

Packaging

Identify as per dwg & Stock Location: \$\square\$50 7 0.00

Dart Aerosp	pace Ltd
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W/O:			WC	ORK ORDER CHANGE	ES				
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DATE	STEP	Description of NC		Corrective Action Section		Verific	cation		Approval
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Monday, March 29, 2010 9:54:55 AM

Page 4

Item ID:

D3910-1

Accept

Setup Start

Stop



Revision ID:

Item Name: Crosstube Lug

Required Date: 4/2/2010

3/29/2010

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

QC:

Operation

Description

Date:

Date: _____

SPC (Y/N):

Set Up/

Tooling:

Date: Date:

Draw

Rev.

Run

Start

Stop



Sequence ID/

Work Center ID

180

QC

Memo

QC21- Final Inspection - Work Order Release

Run Hours

Draw Number

Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

0.00

0.00

10/04/06 TX)

Pull on 2 10-4-5

00/102

Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHANGE	S			····	
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DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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Picklist Print

Monday, March 29, 2010 9:54:55 AM

Work Order ID: 57194

Parent Item:

D3910-1

Parent Item Name:

Crosstube Lug

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Start Date: 3/29/2010

Required Date: 4/2/2010

Page 1

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name D2423

Replacement Mfg/ Item ID Purch Manufactured Bin Primary Item Location No

Last Location

Route Seq ID 100

IPP

Unit of Qty on Measure Hand

Loc Code

Remaining Qty To Pick 560.8751 0.5474

Qty Date Issued

Status Issued

Lug Extrusion

Warehouse Loc Oty Location Main Warehouse

MAT06 560.8751432 43722 . 173.462806 44529 5.7731 45800 381.639237

45800 J.F.S 10/04/01

Dart Aerospace Ltd	Da	rt	Aer	os	pac	Эe	Ltd
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W/O:			WC	RK ORDER CHANG	ES				
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A :	Date: _	<u> </u>
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NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	₹)			
DATE STE	STEP	Description of NC	ļ .	Corrective Action Secti		Verific	cation	Approvai	Approval
	Section A	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	57194
Description: Crosstube Lug	Part Number:	739/0-1
Secondaria Classificate Line	, ar manser.	13.3710-1
Inspection Dwg: 539/0-1 Rev: B		Page 1 of 1

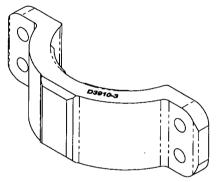
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	C	omments			
4.45	±0.030	4,454	\							
1.38	+0.030	1,38	$\sqrt{}$							
R0,080	±0,020	0,070	/	-		Round E	ige 2PL			
0,27	±0.030	0,275	/			RE	F			
0,31	±0,030	0,303								
R1,20	±0,030	1,20								
0,735	±0,010	0,725	/			RE	F			
0.375	±0,010	0.376	<i>\</i>							
3.700	± 0,010	03.700	V ,			1 1 1				
Ø0.257	to,006/-0,001	0,259	<i>\</i>			4/	<u> </u>			
RO.34	±0,030	0.34				1 1 7	<u> </u>			
0,375	±0,010	0,373	<i>\</i>							
0.625	±0,010	0,623	<i></i>							
2.20	±0,030	2.20								
0.375	+0,010	0.374								
0,38	±0,030	0.374	/ .							
0,625	±0,010	0.623								
RO.38	±0.030	0.38				2	PL			
Ø0,191	+0,005/-0,001	0,193				2				
Measured by:	CITA	Audited by:	1.5		Prototype A	pproval:	N/A			
Date:	10/03/30	Date:	0/03/3	,		Date:	N/A			

	Date:	10/03/30	Date: (2)/23/3/	Date:	N/A
Rev	Date	Change		Revised by	Approved
Α		New Issue		KJ/JLM	

D3910-1

D3910-1 X-TUBE LUG



3

D3910-3 X-TUBE LUG

Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2 10.03.16 NEW ISSUE A JPH 10.03.04 REV. DESCRIPTION DATE BY DESIGN DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3910 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE X-TUBE LUG (350)

COPYRIGHT 6 2016 BY DART AEROSPACE LTD

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THE COLUMN 1 ARMATE HAS CORPEDITING HOST AEROSPACE LTD

THE COLUMN 1 ARMATE HAS CORPEDITING HOST AEROSPACE LTD

THE COLUMN 1 ARMATE HAS CORPEDITING HOST AEROSPACE HAS CONTINUED HAS C DE APPR. NTS DATE 10.03.16

NOTES:

1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005

7) WEIGHT -1: 0.32 lbs -3: 0.25 lbs

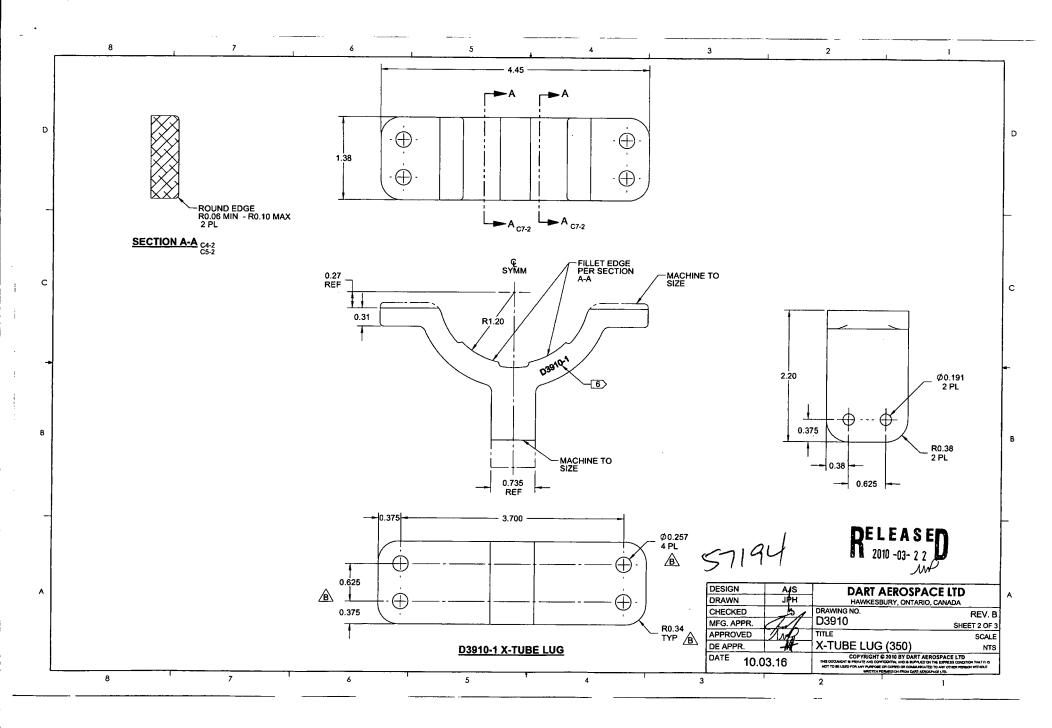
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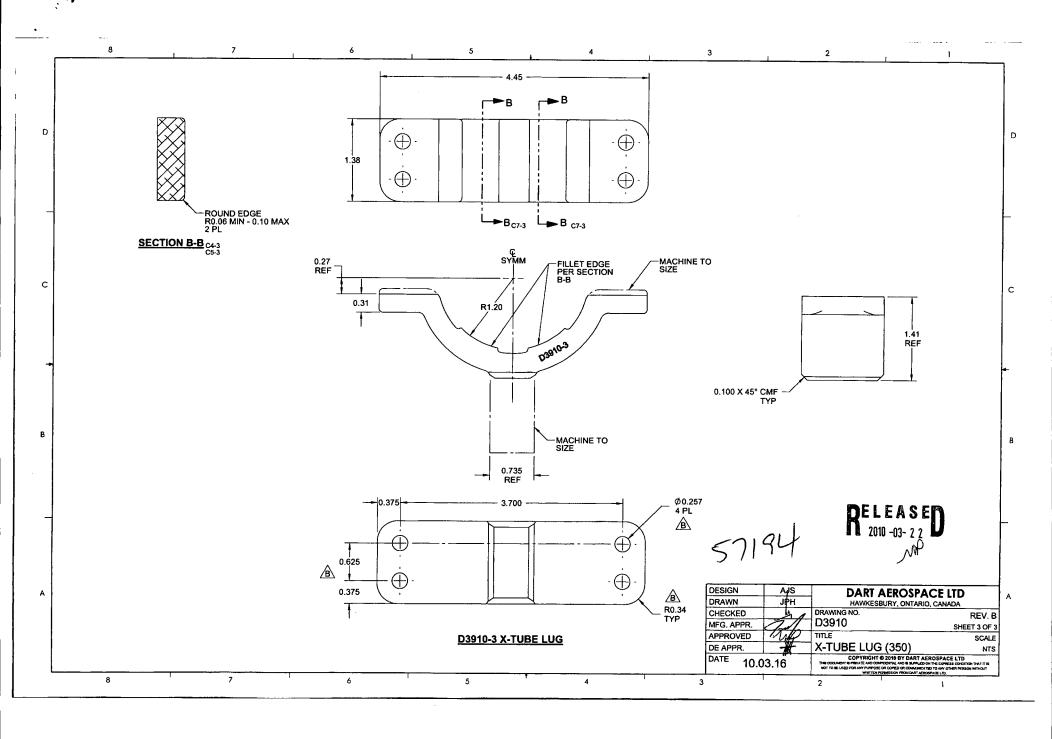
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NOTE: Date & initial all entries

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